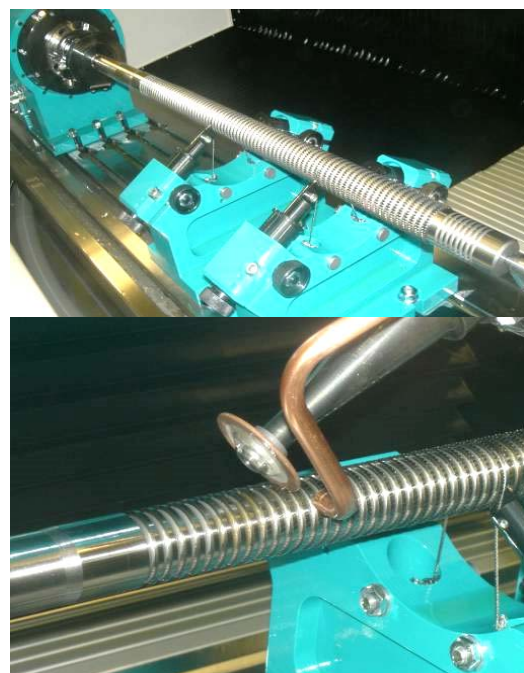







Cylindrical broach Ø40 Z78

A14-020

The resharpener process of this example tool contains the regrinding of the flute and O.D. The teeth can be ground in several sub groups and therefore with different geometry parameters. The division can be reproduced either according to a fix definition in Quinto or the probed division on the tool.



1. Cycletime for Resharpener

Workpiece: Diameter 40mm; Nbr of teeth 78 Material HSS			
Operations			
Feed [mm/Min]	5000	12000	1000
Power [kW]		3	2
Cutting feed [m/s]		30	33
Used wheels			
Grinding time [s]	6	8702	1141
Total cycle time	164 Min 8		

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	14F1 Ø50 B91
2	1V1 Ø125 B91



1

2

3. Machine and Software Requirements

Machines:	6 axes CNC grinders : Corvus BBA	Coolant:	Synthetic Oil, pressure 6 bar
Control:	Fanuc 31i	Software:	Quinto 5
Accessories:	Dog and driver, Hydraulic tailstock, Support		
Responsible engineer:	SIS. 12.2.10		

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